

Date: Thursday, 5/31/2007 7:23:36 AM
 User: Kim Johnston

Process Sheet

POSITIVE RECALL

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32720-1
 Estimate Number : 12577
 P.O. Number : *N/A*
 This Issue : 5/31/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : LARGE FAB ASSY
 Previous Run : 31445
 Written By : *JA*
 Checked & Approved By : *JA 07.05.31*
 Comment : Est Rev:A New Issue 06-11-09 JLM

Drawing Name : STEP WELDMENT

EFFECTIVE *07-06-12* AUTH *u*
 RELEASED DATE

Part Number : D3562042
 Drawing Number : D3562-UNDER REVIEW
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 6/11/2007

Qty: *4* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion *B31984*
B31984

Check Material for any Dents or Defects

FF 07-06-12 4
LE 07-06-04 5

2.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch
 2 D2734 End Cap *B30883*

LE 07-06-04 5

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

a.m

07/06/04

LE (5)

2-Deburr and bevel ends for welding

FF 07-06-12
LE 07-06-07

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod *M102756*

LE 07-06-07 5

4-Grind end cap welds flush as per Dwg D3562

FF 07/06/07 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.07	11	Remove qty (2) MS20600 AD4 Rivets. Total qty now 34. REF MARKED-UP DWG & DS EMAIL				CP 07.06.07 per Q51042		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/31/2007 7:23:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32720

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

QC5

INSPECT WORK TO CURRENT STEP



QC5 07-06-07 (5)



Comment: INSPECT WORK TO CURRENT STEP

QC9 07/04/07 (5)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Debur
Touch-up holes
with Alodine

Drill Rivet holes as per dwg D3562. USING DT 8956

FF 07/06/13 4

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 07-06-12
FF 07-06-07

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FE 07-06-07

9.0

D3560042

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

3.32643

FE 07-06-08 4

10.0

D3560042

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

Batch: 3.32643

FE 07-06-08 4

11.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total: 180.0000 Each(s)

Blind Rivet

batch: m8953

SEE WLD CHANGE

FE 07-06-08 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Thursday, 5/31/2007 7:23:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32720

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet legs using Magnabond as per dwg D3562.

Ensure to wipe off any excess magnabond of the step

A/R

Magnabond 6398

Batch:

M104723

04-2008

FF 07-06-14 4

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M102756

2-Grind end cap welds flush as per Dwg D3562

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch:

M104281

M-L 07/06/15 4X

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.07	19.5	PRESS FIT D2800 SPACER AFTER POWDER COAT B/N _____ N/A done on trans D3560-042/044				 07.06.07 08/1142		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMFNT

Job Number: 32720

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10/6/15 (2)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

**SEE W/O CHANGE FOR STEP 19.5*



7/6/15 S9 (2)

Job Completion



QC 21 Final inspection w/o release 07/06/15

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED *u* DATE *07/06/15*

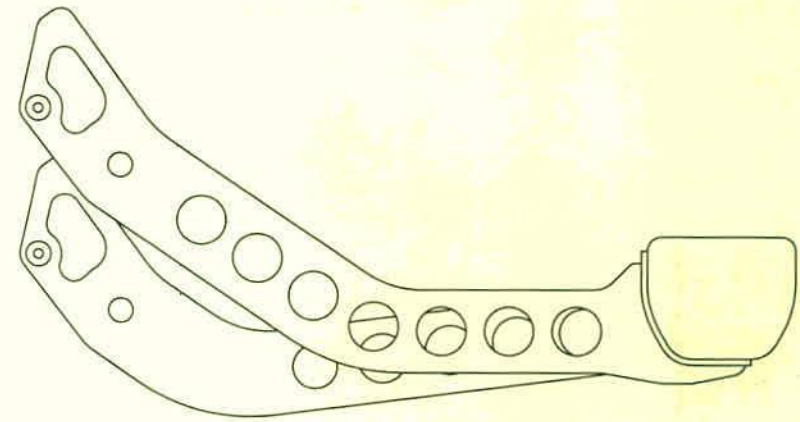
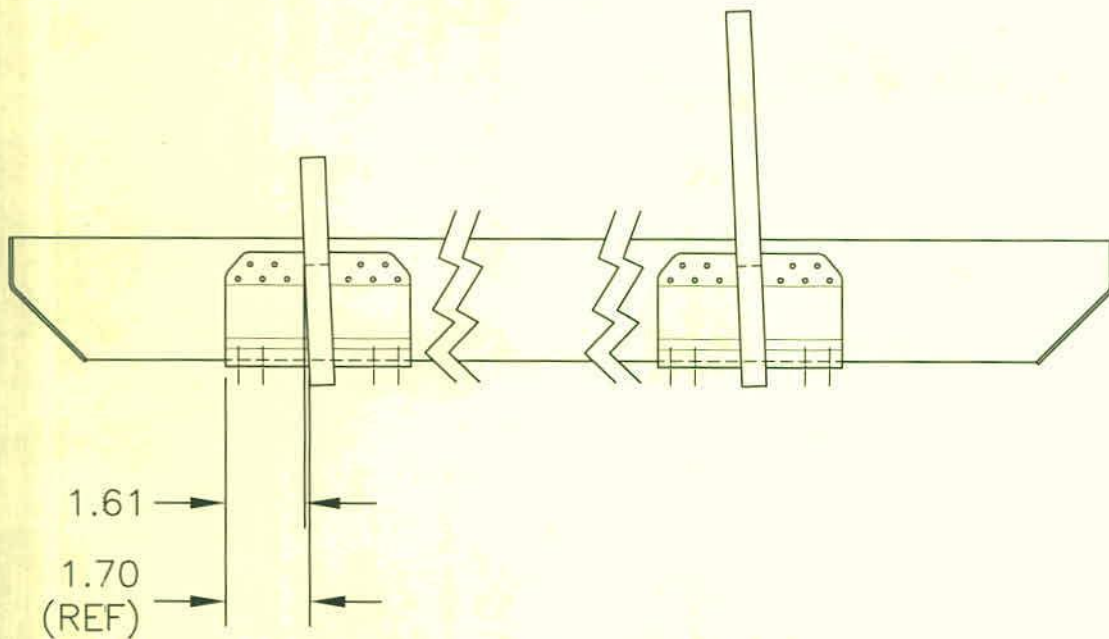
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32720

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 5, 2007 5:18 PM
To: 'Chris Provencal'
Subject: RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, June 05, 2007 11:00 AM
To: David Shepherd (David Shepherd)
Subject: D3562-041/-042

David

For the D3562-041/-042 step weldment, as discussed. They want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond doesn't do anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

-Chris

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Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

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Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 5, 2007 12:26 PM
To: 'Chris Provencal'
Subject: RE: D3560-041/-042/-043/-044

Go ahead.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, June 05, 2007 9:55 AM
To: David Shepherd (David Shepherd)
Subject: D3560-041/-042/-043/-044

David

This is sort of a rush: dwg D3560 Rev.B (step weldment for -033/-034 steps) is not calling up the D2808 Bushing. It is missing the "Press fit D2808 Bushing after powder coat".

We will correct this, but for the time being: is it acceptable to press fit a D2808 Bushing into the D3560-041/-042/-043/-044 as the design originally intended?

-Chris

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Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

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Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 7, 2007 3:37 PM
To: 'Chris Provencal'
Subject: RE: D3562-041/-042

As we discussed, I think this change is acceptable without further qualification.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, June 07, 2007 1:15 PM
To: David Shepherd (David Shepherd)
Subject: D3562-041/-042

David,

For the D3562-041/-042 Step Assembly, we need to remove qty(1) rivet from each D3560-XX Arm weldments attachments for manufacturability. There will be a total qty(34) MS20600AD4 rivets instead of qty(36) per step. The rivet will be removed from the side surface of the step. Remaining shear would be 350 lbs x 16 rivets = 5600 lbs per arm attachments.

-Chris

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Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.11/838 - Release Date: 6/7/2007 2:21 PM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.11/838 - Release Date: 6/7/2007 2:21 PM

